



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

D3121-144

Job Sheet 181853



Part No: D3121-144

Job Qty: 10 ea

Part Name: Bracket Assembly



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 8/9/18

Job Tracking No:

Due Date: 8/17/18

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG REV E IPP Rev:Pick:A 04.02.18 New issue KJ/DS IPP Rev:B ECN 1060 07-11-12 DD verified by:EC IPP
Rev:C New Dimensions for Blank Size 08-07-23 JLM Verified By:EC

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	10 Ea	8/17/18	8/17/18	0.00	0.00	Start Up Machining-1		
100	Bandsaw	10 pcs	8/17/18	8/17/18	0.00	3.89	Bandsaw1		
110	CNC Vertical Machining	10 pcs	8/17/18	8/17/18	0.36	21.28	HAAS1-3		
120	QC	10 pcs	8/17/18	8/17/18	0.00	0.00	QC2 Machining-1		
130	QC	10 pcs	8/17/18	8/17/18	0.00	0.00	QC8 Machining-1		
140	Small Fab	10 pcs	8/17/18	8/17/18	0.00	0.56	Small Fab-2		
150	QC	10 pcs	8/17/18	8/17/18	0.00	0.00	QC5		
160	Packaging	10 pcs	8/17/18	8/17/18	0.00	0.00	Packaging3-1		
170	QC21-SA	10 Ea	8/17/18	8/17/18	0.00	0.00	QC21		

Part Op 100 - Cut blanks: (1.250" x 2.000") 4.425" long
Descriptions: 110 - 1-Machine D3121-114 as per Folio FA330 and Dwg D3121 Identify as D3121-114
140 - Assemble D3121-143 as per Dwg D3121.

5088987

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M17-4-B1.250X2.000	17-4 SS Bar 1.250 x 2.00	3.6800 ft (.368 ea)	90-Start up Operation	
D3121-21	Bolt	20 Ea (2 ea)	140-Small Fab	
D3121-241	Bearing Assembly	20 Ea (2 ea)	140-Small Fab	

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	M17-4-B1.250X2.000	4	26	0
140-Small Fab	D3121-21	20	115	0
	D3121-241	20	10	0

Part Specifications

Specifications could not be found.

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td colspan="2"></td> </tr> </table>				Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐		
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Date : _____	Step #: _____	2) Approval ☐																			
Description Work Order Deviation																					
1270 Aberdeen Street Markham, ON L3R 9K7 CANADA TEL: 1 613 632-6200 Email: sales@dartaero.com www.dartaerospace.com Container No: S104650 Part: D3121-144 Job No: 181853 Serial No/Batch: S104650 Revision: _____ Inspector: _____ Exp Date: _____ Instructions: Various STC's Date: 08/23/18																					
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DART AEROSPACE LTD		Work Order:	181853
Description: Bracket		Part Number:	D3121-114
Inspection Dwg: D3121	Rev: E	Page 1 of 2	

FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.080	+/-0.010	0.080	✓		Kt-05	Verm
0.300	+/-0.010	0.300	✓		" "	" "
R0.375	+/-0.010	0.375	✓		" "	" "
1.54	+/-0.030	1.540	✓		31006	H-G
0.350	+/-0.010	0.350	✓		" "	" "
R0.25	+/-0.030	0.250	✓		—	R-G
Ø0.392	+0.002/-0.000	0.393	✓		Kt-01	micrometre
Ø0.201	+/-0.010	0.201	✓		Kt-05	Verm.
0.100	+/-0.010	0.100	✓		" "	" "
2.540	+/-0.010	2.540	✓		31006	H-G
1.590	+/-0.010	1.590	✓		" "	" "
0.160	+/-0.010	0.160	✓		Kt-05	Verm.
0.400	+/-0.010	0.400	✓		" "	" "
1.220	+/-0.010	1.220	✓		31006	H-G
1.600	+/-0.010	1.600	✓		Kt-05	Verm.
3.80	+/-0.030	3.800	✓		" "	" "
1.800	+/-0.010	1.800	✓		" "	" "
R0.50	+/-0.030	0.500	✓		—	R-G
0.130	+/-0.010	0.131	✓		Kt-05	Verm.
3.41	+/-0.030	3.41	✓		" "	" "
3.65	+/-0.030	3.65	✓		" "	" "
2.24	+/-0.030	2.210				
45°	+/-0.1°	45°	✓		—	A-G
R0.25	+/-0.030	0.250	✓		—	R-G
3.97	+/-0.030	3.970	✓		Kt-05	Verm.
R0.38	+/-0.030	0.380	✓		—	R-G
Ø0.392	+0.002/-0.000	0.3932	✓		Kt-01	micrometre
Ø0.201	+/-0.010	0.201	✓		Kt-05	Verm.
0.268	+/-0.010	0.268	✓		" "	" "
R0.260	+/-0.010	0.260	✓		" "	" "
0.080	+/-0.010	0.080	✓		" "	" "
0.300	+/-0.010	0.300	✓		" "	" "
0.381	+/-0.010	0.385	✓		Kt-05	Verm.
0.201	+/-0.010	0.201	✓		" "	" "
0.580	+/-0.010	0.585	✓		" "	" "

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

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Date :	Step #:	QTY Effective :		MRB (QSI042) Approval																	
Description Work Order Deviation			Disposition																		
						Completed By															
						Lead hand / Supervisor Approval Verification															
			QC / QA Coordinator Approval																		
Root Cause		FAULT CATEGORY																			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐																
OTHER : ☐																					

DQA: _____ Date: _____

**WORK ORDER NON-CONFORMANCE / UPDATE**

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION		AGAINST DEPARTMENT/PROCESS							
	Rework	☐	Skid-tube	☐	Cross tube	☐	Water Jet	☐	Engineering	☐
	Scrap	☐	Machining	☐	Small Fab	☐	Prod. Eng. Coord.	☐	Quality	☐
	Use-as-is	☐	Thermoforming	☐	Finishing	☐	Rec/Store/Packaging	☐	Other	☐
	Suspected Unapproved	☐	Large Fab	☐	Composite	☐	Supplier	☐		

Date :	Step #:	QTY Effective :	MRB (QSI042) Approval
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Description Work Order Deviation	Disposition	
		Completed By
		Lead hand / Supervisor Approval Verification
		QC / QA Coordinator Approval

Root Cause				FAULT CATEGORY							
Environment	☐	No Re-verification	☐	Pressure/Forced	☐	Temperature/Cure	☐	Power Loss/Surge	☐	Positioned Wrong	☐
Design	☐	Operator	☐	Bending	☐	Set-up	☐	Folio/Program	☐	Outside Dimensions	☐
Doc/Data	☐	Offset/Setup	☐	Centre Not Concentric	☐	BOM/Route	☐	Grain	☐	Over/Under tolerance	☐
Equip/Tooling	☐	Supplier	☐	Cracks	☐	Broken/Damage/Defect	☐	Weld	☐	Part Incorrect	☐
Handling/Pre	☐	Training	☐	Crimp/Kink/Ripple/Wave	☐	Inspection Incomplete/Unqualified	☐	Wrong Stock Pulled	☐	Part Lost/Missing	☐
Material	☐	Use for Testing	☐	Cuffs	☐	Contamination	☐	Out of Sequence	☐	Part Moved	☐
Internal Transport	☐	Poor Information	☐	Crushing	☐	Countersink	☐	Off-set	☐	Drawing	☐
Tribal Knowledge	☐	Rushing	☐	Heat Treat	☐	Cut Too Short	☐	Mislabeled	☐	Finish	☐
LOA	☐	Product Improvement	☐	Wave/Twist in Tube	☐	Instructions Incomplete/Unclear	☐	Fit/Function	☐	Misread	☐
Substation	☐	Process Improvement	☐	Marks/Chatter	☐	Drill Holes	☐	Misaligned/off center	☐	Turning Sequence	☐
Past Expiry Date	☐	Manufacturing Process	☐	OTHER :							
Misidentified	☐	Past Due	☐								